

Stock

Work Order ID 137348

137348

Page 1

September 24, 2015 2:56:12 PM

Item ID: D3805-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Plate
 Start Date: 9/24/2015 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 10/8/2015 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: SH Date: 0150924 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3805	C								
100		0.00							
100									
Waterjet	Memo	0.01							
FLOW CNC Waterjet	1-Cut as per Dwg D3805								
	Dwg Rev: C								
	Prog Rev: C								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

6

09/24/15

6

09/24/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 16.6%;">Skid-tube ☐</td> <td style="width: 16.6%;">Cross tube ☐</td> <td style="width: 16.6%;">Water Jet ☐</td> <td style="width: 16.6%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 137348

September 24, 2015 2:56:12 PM

137348

Page 2

Item ID: D3805-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Plate

Stop ***NS2***

Start Date: 9/24/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/8/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(6) 1509.25 20

130

0.00

130

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3805 using Jigs DT8261 and DT8326

DAS
30
9-89

6

SEP 28 2015

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

(6)

DAS
38
9-89

SEP 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 137348

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Item ID: D3805-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Plate

Stop ***NS2***

Start Date: 9/24/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/8/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>W/1051</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging	LOCATION WA001								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.01							
Quality Control									

6 EL 15-9-30MUS OCT 01 2015Stt **20150930**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
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				OTHER :							

Picklist Print

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Page 1

Work Order ID: 137348

137348

Parent Item: D3805-5

D3805-5

Parent Item Name: Plate

Start Date: 9/24/2015

Required Date: 10/8/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	222.6776	1.587	10.02316			

M304S18GA

304/316 .050 Sheet

09/25/15

Location	Loc Qty	Loc Code
MAT020	135.6276	
M128254	1.6887	
M128435	25	
M128864	31.5964	
M129530	27.3667	
M130923	28.0424	
M131384	17.4334	
M132797	4.5	
MAT20	87.05	
M131700	87.05	

10

8

7

6

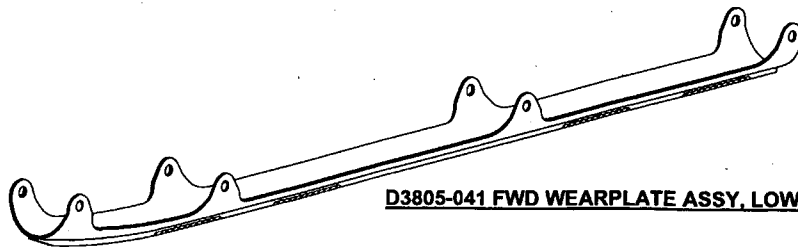
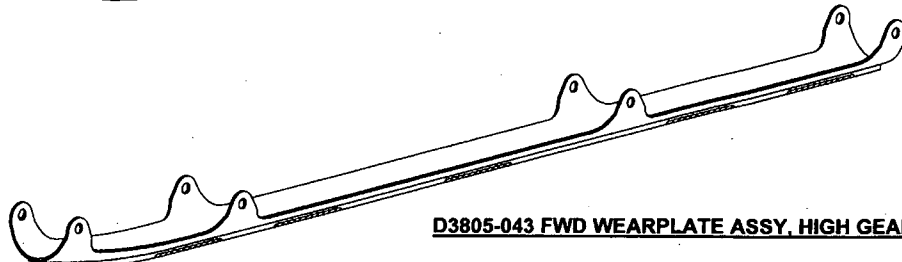
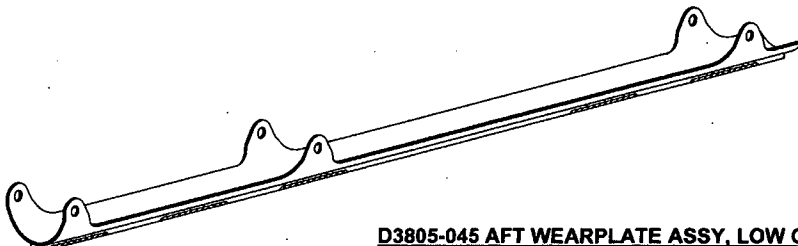
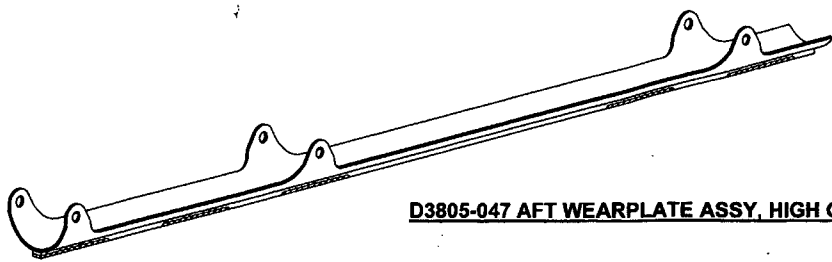
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4

3

2

1

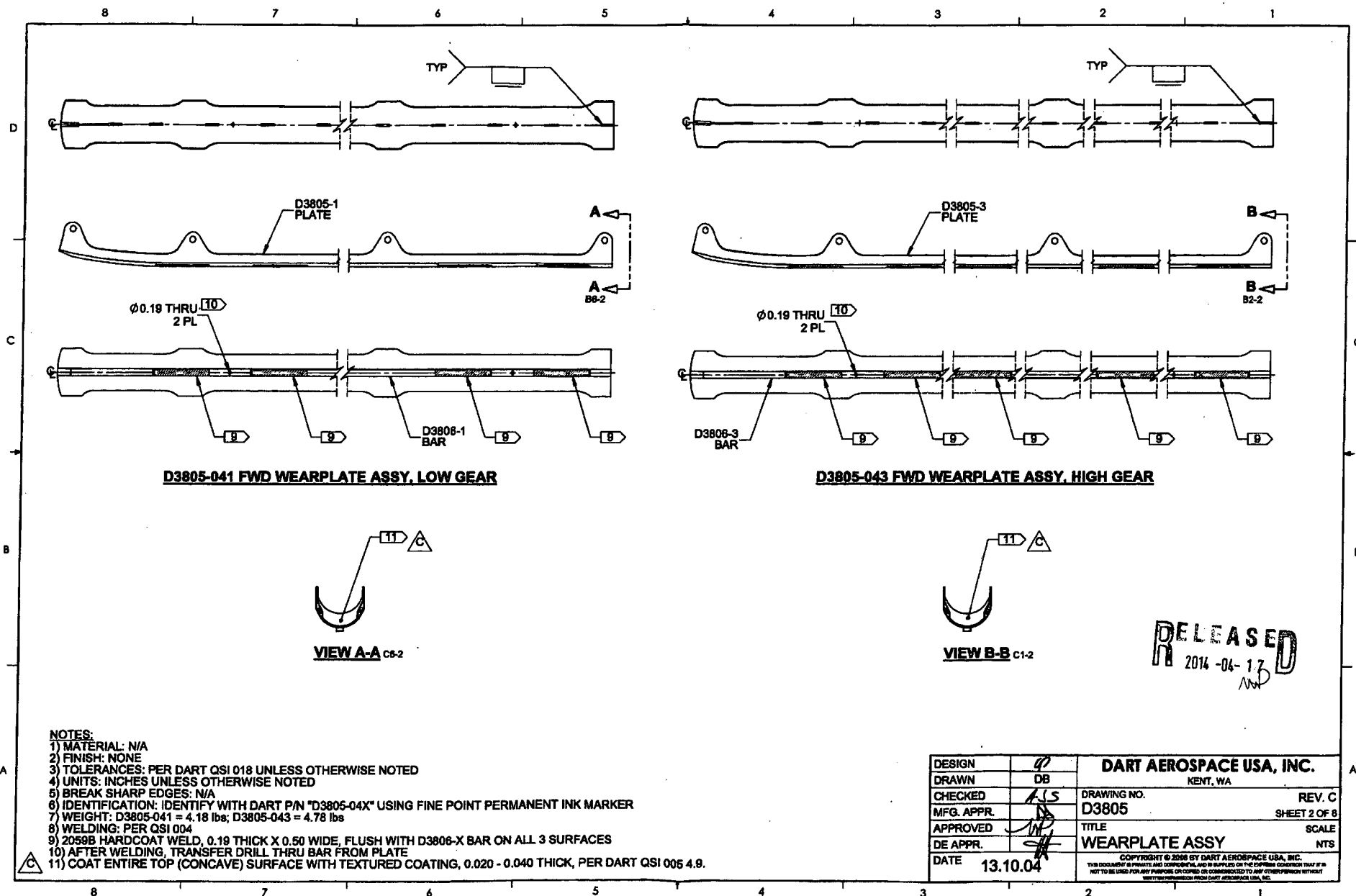
**D3805-041 FWD WEARPLATE ASSY, LOW GEAR****D3805-043 FWD WEARPLATE ASSY, HIGH GEAR****D3805-045 AFT WEARPLATE ASSY, LOW GEAR****D3805-047 AFT WEARPLATE ASSY, HIGH GEAR**

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT

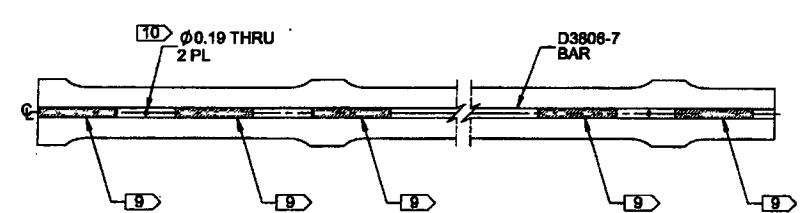
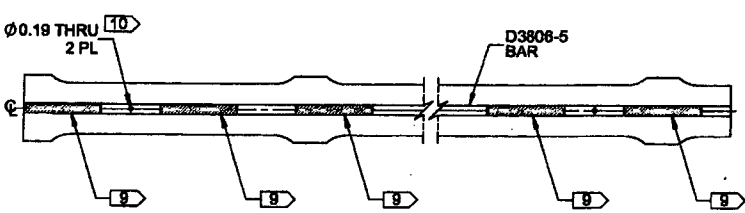
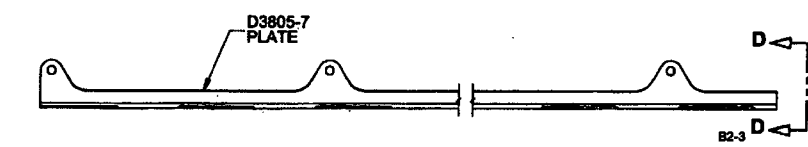
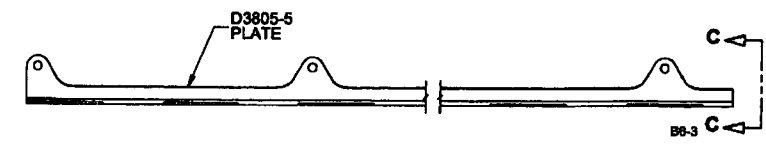
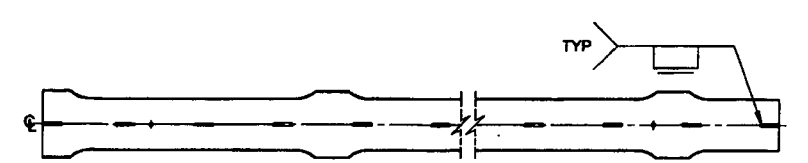
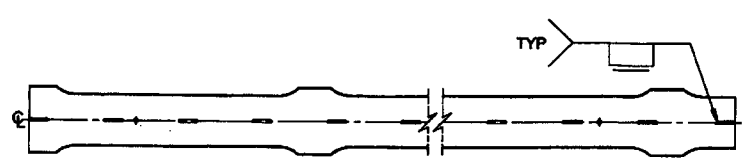
RELEASED
2014-04-17

20150924 SH 137348

C	REMOVE ITEMS 19, 20, 21, 22 AND 32 FROM BOM (ZN C4-1), REVISE NOTE 11, SHEETS 283 (ZN A8-2, B2-2, B6-2, A8-3, B2-3, B6-3)	DB	13.10.04
B	REVISED D3805-1F/3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PAR11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3805	SHEET 1 OF 8
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	WEARPLATE ASSY	NTS
DATE	13.10.04	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

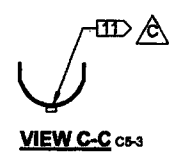


8 7 6 5 4 3 2 1

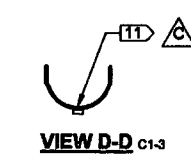


D3805-045 AFT WEARPLATE ASSY.

D3805-047 AFT WEARPLATE ASSY.



VIEW C-C C5-3



VIEW D-D C1-3

RELEASED
2014-04-17

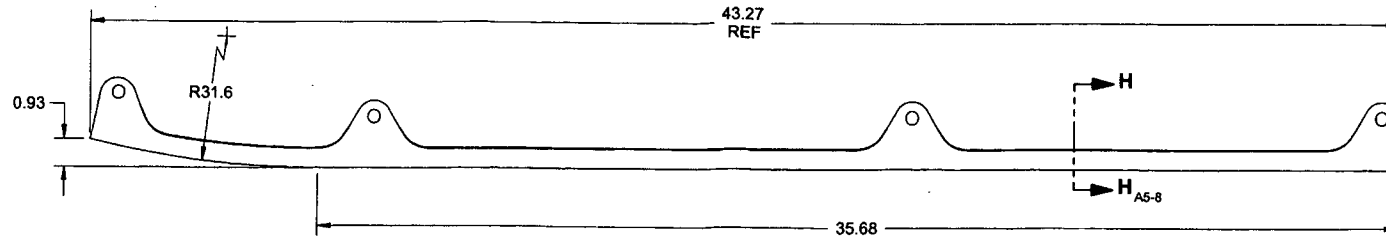
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3805-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

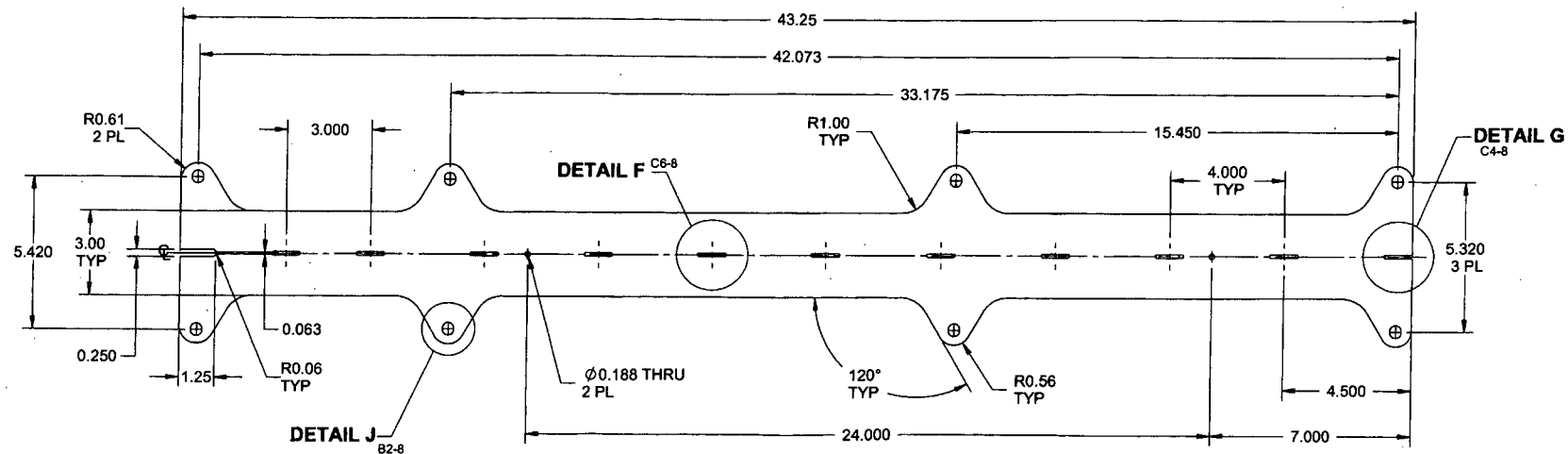
DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D3805-1 PLATE
(MAKE FROM D3805-1F)



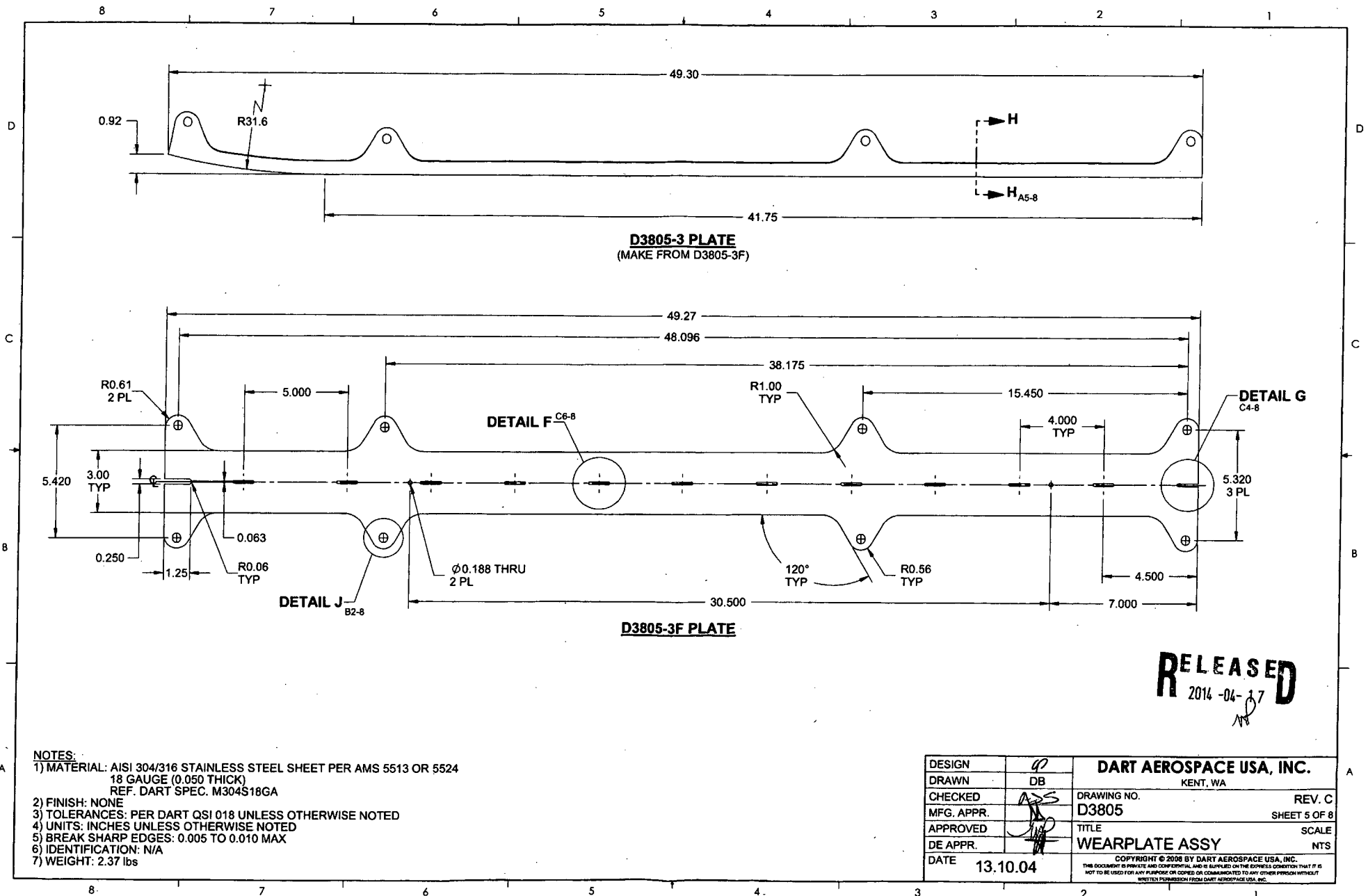
D3805-1F PLATE

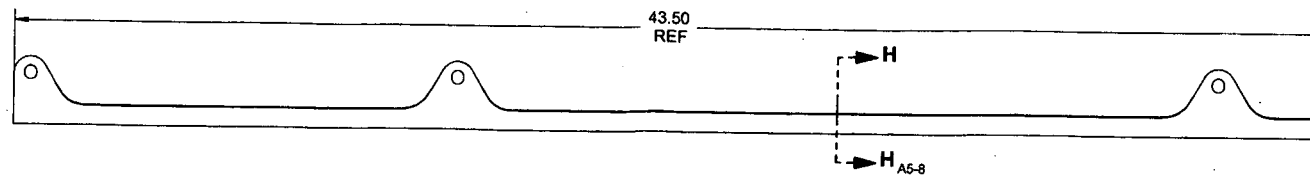
RELEASED
2014-04-17

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.11 lbs

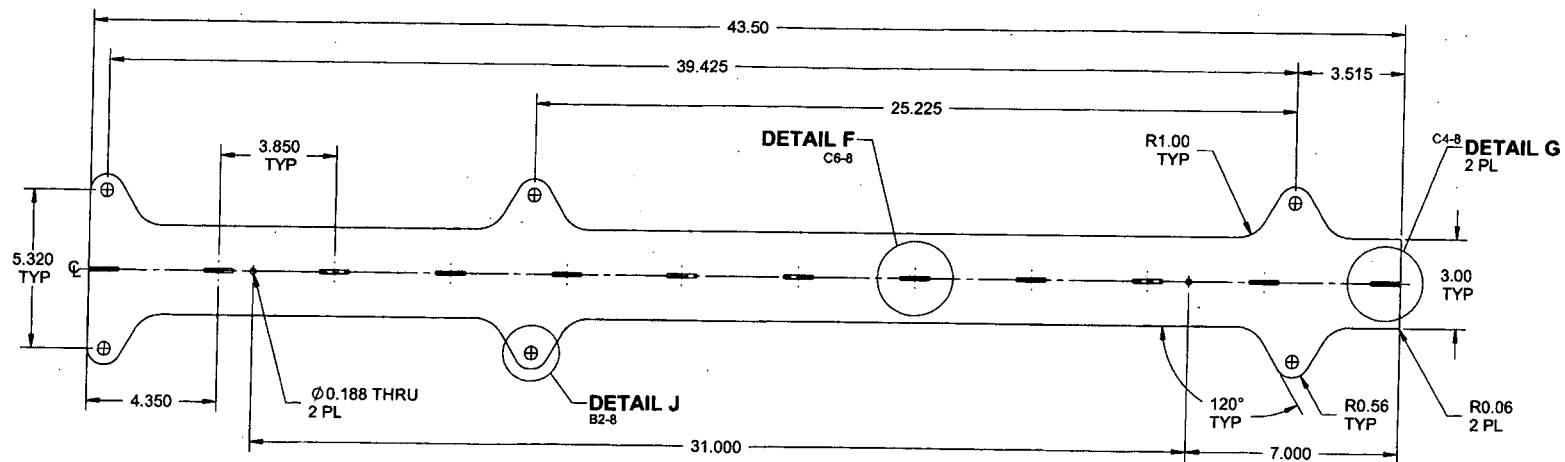
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DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 4 OF 8
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8 7 6 5 4 3 2 1





D3805-5 PLATE
(MAKE FROM D3805-5F)

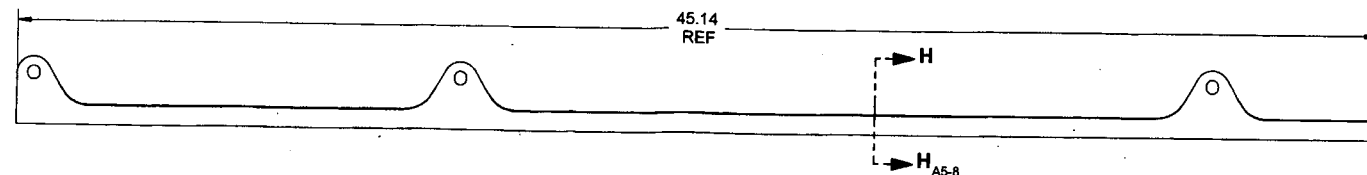


D3805-5F PLATE

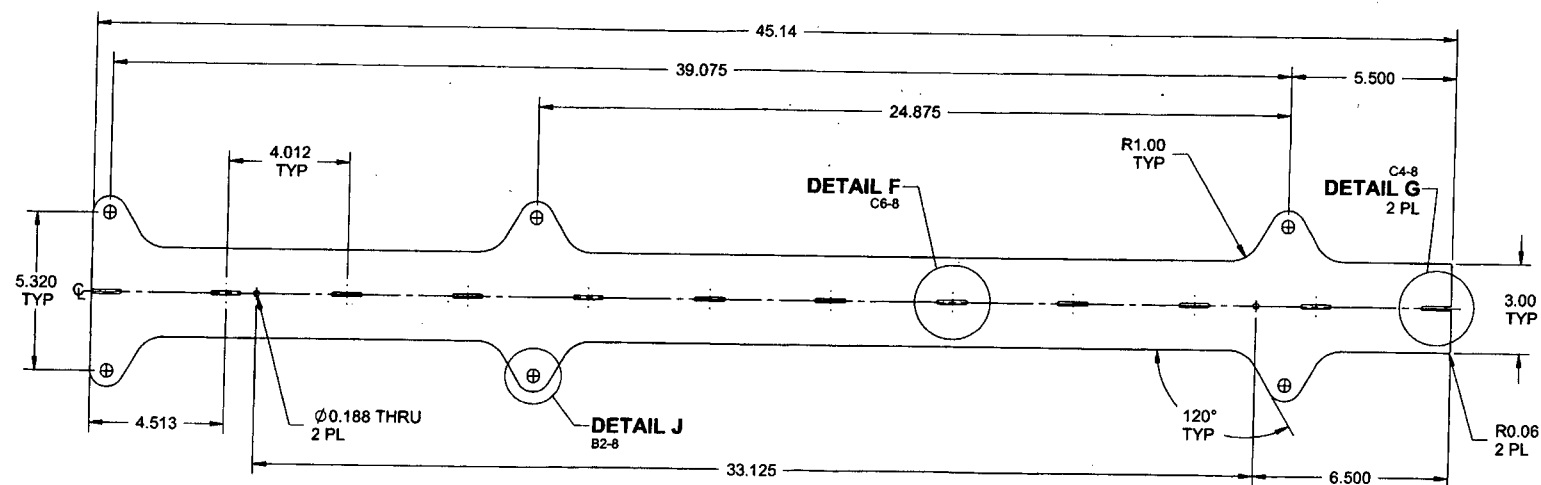
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- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.06 lbs

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MFG. APPR.	<i>[Signature]</i>	D3805	SHEET 6 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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D3805-7 PLATE
(MAKE FROM D3805-7F)



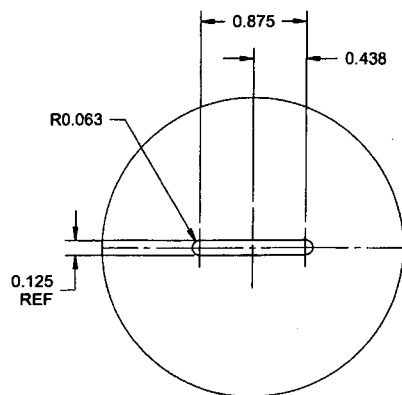
D3805-7F PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

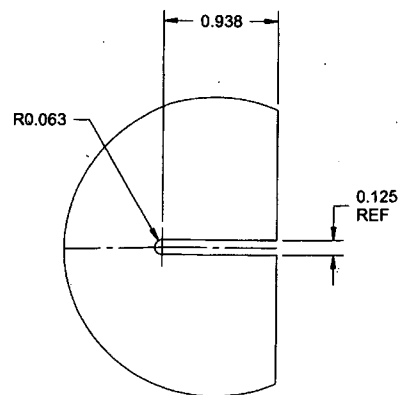
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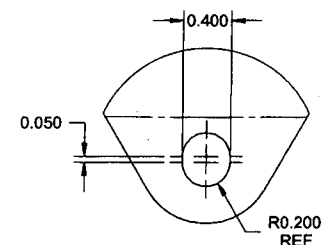
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SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



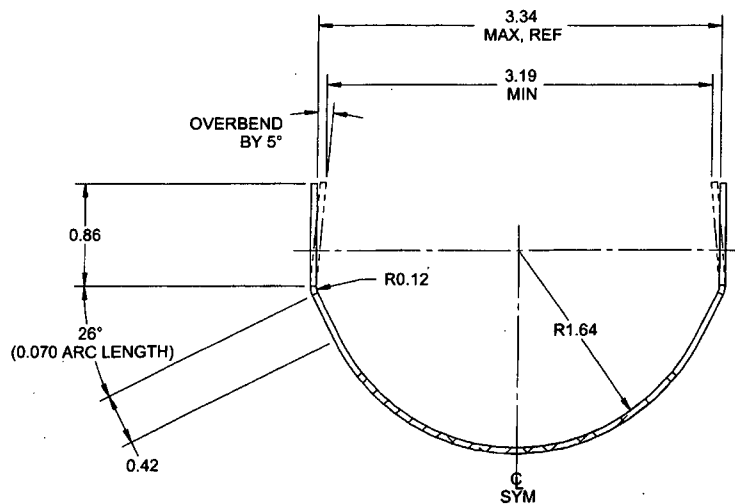
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

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APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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